Work Order ID 95330 Page 1 January-09-13 10:11:17 AM D2161-212 Item ID: Accept *N900040100* Setup Start **Revision ID:** Item Name: Mirror Bracket, 212 **Start Otv: 4.00 Start Date:** 1/15/13 **Cust Item ID:** Required Date: 1/15/13 **Req'd Qty:** 4.00 Customer: Reference: Run Start Process Plan: MLJ Date: 13-01-11 Tooling: Approvals: Date: Stop OC: Date: SPC(Y/N): Date: Sequence ID/ Operation Tool ID Tool # Reject Set Up/ Plan Accept Reject Insp. **Work Center ID** Number Stamp Description Otv **Run Hours** Code **Oty** Draw Nbr Revision Nhr Rev B2 D2161 100 Weld per dwg A/R. S.S. rod Batch: /// 2352 A 13-1-15 Large Fab *100* Large Fab 0.00 Memo Large Fab 1-Assemble on Jig DT8065 as per Dwg D2161 2-Weld as per Dwg D2161 Identify as D2161-212 110 QC9- Inspect visual per QSI004- Fusion Welds 13.1.15 *110* 0.00 Memo Quality Control 120 QC5- Inspect part completeness to step on W/O 0.00 *120* QC 0.00 Memo Quality Control

											•	DQA:	Date	:			
NCR:	Yes	/ No					WORK ORDER NON-O	COI	NFORN	AANCE / UPI	DATE	QA Closed:	 Date	:			
Vork Ord	er:						DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Part No							Rework Scrap Use-as-is Work Order Update			Skid-tube Crosstube Small Fab Thermoforming Finishing Composite			Water Jet d. Eng. Coor. re/Packaging Supplier	⊣ -	neering Quality Other		
Root					Des	crip	otion of work order update		nitial	Act	ion	Sign &					
Cause		Date	Step	Qty		C	r Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC	Inspector		
oc/Data puip/Tooling perator laterial etup ther rocess upplier raining							·		€====================================								
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Landi	$\overline{}$	l			1		General		1		٦	7	-	¬_			
		Bending Centre No Cracks Crushed/O Cuffs Heat Trea Inspection Ripples in Torque W Turning So	Crimped. It In Strip in Bend Vaves in E	Tube			Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish		Instruct Mainte Mislabe Misread Offset Out of O	on Incomplete ions Incomplete/U nance led	Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct issing Wrong	Tempe Weld	re/Forced erature/Cure g Stock Pulled		

Outside Dimensions

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 95330 Page 2 January-09-13 10:11:17 AM Item ID: D2161-212 Accept *N900040100* Setup Start **Revision ID:** Mirror Bracket, 212 Item Name: **Start Date:** Start Qty: 4.00 1/15/13 **Cust Item ID:** Required Date: 1/15/13 **Req'd Qty:** 4.00 **Customer:** Reference: Run Date: ____ **Approvals:** Process Plan: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code **Qty** Qty Number Stamp Black Sandtex(Re£43.5.7) per QS1005 4.3 130 0.00 *130* Powdercoat Powder Coating 140 QC3- Inspect Part Finish *140* 0.00 13.7, 16 QC Memo Quality Control

150

Identify as per dwg & Stock Location:

150

Packaging

Memo

0.00

Packaging

V 5

												DQA:	Da	te:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE		•		•	
											(QA Closed:	Da	te:	•
Work Orde	er.					DISPOSITION				AGAINST D	ΕP	ARTMENT/	PROCESS		
Work Order.						Rework	7		Skid-tube Crosstube				Water Jet		Engineering
Part I	۷o.					Scrap		Machining	Small Fab	1	Proc	d. Eng. Coor.		Quality	
						Use-as-is	Thern	noforming	Finishing		Rec/Stor	e/Packaging		Other	
NCR f	No.					Work Order Update]		Large Fab	Composite			Supplier		
			1				1				_				
Root					1	ption of work order update		Initial		tion		Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription	\perp	Date	Verificatio	n	QC Inspector
Doc/Data															
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		Bending				Bend		Grain			<u></u>	Ovalized		L	Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		ال	Over/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete			Part Incorrect			Weld
		Crushed/	Crimned			Burrs		Instruct	ions Incomplete/	٦	Part Lost/Mi	ssing		Wrong Stock Pulled	

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

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Work Orde January-09-13								Page 3				
Revision ID:	D2161-212 Mirror Brack	et, 212		Accept	*N900040100				Setup S	Start Stop	1 41 4	S1* S2*
Start Date: Required Date: Reference:	1/15/13 1/15/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	D:						
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		nte:		1		Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center II 160 *160* QC Quality Control)	Operation Description QC21- Final Inspection Memo	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	. i	Reject Number	Insp. Stamp

P13-01-16

												DQA:	Da	te:	
NCR:	Yes	/ No				WORK ORDER NON-O	100	NFORM	ANCE / UP	DATE		•		•	,
		•									(QA Closed:	Da	te:	
Work Orde	er.					DISPOSITION				AGAINST D	ΕP	PARTMENT	PROCESS		
Work Order: Part No. NCR No.						Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab			Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other	
Root					Descri	ption of work order update	1	Initial	Ac	tion	T	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verificatio	n	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved															
							AUL	T CATE	GORY						
Landi		Bending Centre No Cracks Crushed/ Cuffs Heat Trea	Crimped. et		o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Inspecti Instruct Mainte	Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Over/Under tolerar Part Incorrect Part Lost/Missing Part Moved Positioned Wrong				ct ssing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Ripples in	Bend			Drill Holes		Offset							

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

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Picklist Print

January-09-13 10:11:16 AM

Work Order ID:

95330

Parent Item:

D2161-212

Parent Item Name:

Mirror Bracket, 212

Start Date: 1/15/13

Required Date: 1/15/13

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP D02.04.15Added dwg Rev.B1 and finishNG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2013-3 Mirror Bracket LH, 212		Manufactured	No			100	Each	6.0000	1	C 4	3-/-	14	
				Location WA001	74	<u>Loc Qty</u> 6 1	Lo	c Code					
D2013-4		Manufactured	No	830 890	_	1 4 100	Each	10.0000	1	9 A 4/1	3 <i>- - </i> 4	Z	
Mirror Bracket RH, 212				Location WA001		<u>Loc Qty</u> 10	<u>Lo</u>	c Code			<u>)</u>		### ##################################
D2037-101		Manufactured	No	859 899	-	6 4 100	Each	7.0000	1	y 4/1	 3-1- /		
Arm				Location WA001		Loc Oty 7	<u>Lo</u>	c Code					
				807 2 09		3 4				4			

											DQA	۸: Dat	e:				
NCR:	Yes	/ No				WORK ORDER NON-O	WORK ORDER NON-CONFORMANCE / UPDATE										
										•	QA Close	d: Dat	e:				
Work Orde	۵r·					DISPOSITION				AGAINST DE	PARTMEN	T/PROCESS					
WOIR OIG	_			-		Rework	1		Skid-tube	Crosstube]	Water Jet		Engineering			
Part I	۷o					Scrap		Machining	Small Fab	4	rod. Eng. Coor.		Quality				
NCD A	\.								noforming	Finishing	Rec/St	ore/Packaging	ᅴ	Other			
NCR I	۱O					Work Order Update	j		Large Fab	Composite	j	Supplier					
Root					Descri	ption of work order update		Initial	Ac	tion	Sign &						
Cause	\dashv	Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	1	QC Inspector			
Doc/Data	Ш																
Equip/Tooling	Ш											1					
Operator	Ц						1						İ				
Material	Щ						1	,									
Setup	Ш	*											1				
Other	Ш																
Process	Ш																
Supplier	Ш																
Training																	
Unapproved																	
						F.	AUI	T CATE	GORY								
Landi	ng G	ear				General		-			_						
	Ш	Bending				Bend		Grain		<u>L.</u>	Ovalized	į		Pressure/Forced			
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Und	er tolerance		Temperature/Cure			
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incor	rect		Weld			
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/	'Unclear	Part Lost/	Missing		Wrong Stock Pulled			
		Cuffs				Contamination		Mainte	nance		Part Move	ed		· *-			
		Heat Trea	it			Countersink		Mislabe	led		Positioned	d Wrong		_			
		Inspection	n Strip in	Tube		Cut Too Short		Misread	İ		Power Los	ss/Surge		Other			
		Ripples in	Bend			Drill Holes		Offset			-	•					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

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